

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027284**Date Inspected:** 07-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Westmont Industries**Location:** Santa Fe Springs. Ca

CWI Name:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** SAS Travelers**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the Westmont Industries (WMI) job site in Santa Fe Springs, California between the times noted above in order to monitor fabrication and the Quality Control functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path). The following items were observed:

Modified Brake Mounts Traveler Trolley Train Links (CCO232)

This QA Inspector randomly observed WMI production welder Mr. Mike Ruiz (WID # 3155), performing welding activities on material ASTM A572 Grade 50 angle 8" x 8" x 7/8" x 1-3-1/4" angle material joining angle plates to link suspension plates 2A, 2B, 3A, & 3B. Mr. Lopez was observed welding using approved Flux Cored Arc Welding with Gas (FCAW-G) process, welding fillet and groove welds in all positions through the day.

Modified Brake Mounts Traveler Trolley Train Links (CCO232)

This QA Inspector randomly observed WMI production welder Mr. Eutimo Huerta (WID # 3035), performing welding activities on material ASTM A572 Grade 50 angle 8" x 8" x 7/8" x 1-3-1/4" angle material joining angle plates to link suspension plates 2A, 2B, 3A, & 3B. Mr. Lopez was observed welding using approved FCAW-G process, welding fillet and groove welds in all positions through the day.

The welders listed above performed work on identical projects at separate locations.

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This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

Maintenance Travelers

This QA Inspector performed random shop observations and observed that Zemarc Corporation is on site at WMI today. Zemarc personnel informed this QA Inspector that Zemarc will continue installing various sizes of compressed air lines and console frames on the SAS-EB, E2/E3-EB, E2/E3 WB Maintenance Travelers today.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI is on site to continuing with the coating application. This QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI will be onsite tomorrow at 0600, 3/8/12, to perform adhesion tests and to continue touch up applications on the Bike Path Traveler Assemblies and the SAS Travelers.

This QA noted above items observed appear to comply with the contract documents.

Summary of Conversations:

As noted above.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for

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your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer